



- NOTES:
1. THIS IS A ULTRA-HIGH VACUUM COMPONENT (UHV).
  2. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:  
A) CIMCOOL 5 STAR 49  
B) TRIM SOL
  3. ALL SURFACES MUST BE MACHINED FOR CLEAN UP.
  4. TUNGSTEN ALLOY OF 95% TUNGSTEN OR MORE WITH REMAINDER NICKEL AND IRON.  
TO COMPLY WITH MIL. SPEC. T-21014D, CLASS 4
  5. FINISHING: WHEN MACHINING VACUUM PARTS, USE OF ABRASIVE PAPER OR SANDING DISCS, BUFFING OR POLISHING COMPOUNDS, OR RESIN-BONDED GRINDING WHEELS IS PROHIBITED.
  6. CLEANING: THE COMPONENT MUST BE CLEANED SUCH THAT A UHV PRESSURE OF 1 x 10<sup>-10</sup> TORR CAN BE ACHIEVED.
  7. HANDLING: CLEAN COMPONENTS SHALL BE HANDLED WITH WHITE SILK GLOVES AND WRAPPED WITH ALUMINUM-FOIL-TYPE DRY ANNEAL A UNDER CLEAN ROOM CONDITIONS.
  8. BREAK ALL SHARP CORNERS .02.
  9. ALL DIMENSIONS IN [ ] ARE MILLIMETERS AND ARE FOR REFERENCE ONLY.

ITEM		DWG. & ELECTRONIC FILE NO.		NOMENCLATURE OR DESCRIPTION		MATERIAL / SPEC		QTY	
				PARTS LIST					
		UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES		ELECTRONIC FILE NUMBER <b>A18184</b>		THIS DRAWING IS THE PROPERTY OF <b>ARGONNE NATIONAL LABORATORY</b>			
		TOLERANCES		DRAWN BY <b>RICK KRAKORA</b>		DATE <b>12/92</b>		CHIEF DESIGN ENGINEER <b>D. SHU</b>	
		DECIMALS ANGULAR		CHECKED BY <b>T. SANCHEZ</b>		DATE <b>7/26/93</b>		DATE <b>8/9/93</b>	
		XXX - .005 - .020 - .050 - .100 - .150 - .200 - .250 - .300 - .350 - .400 - .450 - .500 - .550 - .600 - .650 - .700 - .750 - .800 - .850 - .900 - .950 - 1.000		DESIGNED BY <b>RICK KRAKORA</b>		DATE <b>12/92</b>		PROJECT MGR <b>T. KUZAY</b>	
		SURFACE ROUGHNESS		RESPONSIBLE ENGINEER <b>T. SANCHEZ</b>		DATE <b>7/26/93</b>		APPROVED/RELEASED	
		REMOVE ALL BURRS AND BREAK SHARP EDGES TO MAX. ACCORDANCE WITH LATEST AND B46.1		MATERIAL <b>SEE NOTE 4</b>		SCALE <b>1=1</b>		SIZE <b>D</b>	
		OBSERVING & TOLERANCING IN ACCORDANCE WITH LATEST AND 11.4						DRAWING NUMBER <b>P4102010108-230003-01</b>	
		DO NOT SCALE DRAWING							
01 DIM. 250 WAS .72		RK		CHD		DATE			
010 CHANGE DESCRIPTION		BY		CHD		DATE			
		REVISIONS							